

NAVSHIPREPFAC YOKOSUKA
LOCAL STANDARD ITEM

FY-02

ITEM NO: 099-25YO
DATE: 01 JUL 2000
CATEGORY: II

1. SCOPE:

1.1 Title: Structural Boundary Test; accomplish

2. REFERENCES:

- a. MIL-STD-777, Schedule of Piping, Valves, Fittings, and Associated Piping Components for Naval Surface Ships
- b. 802-5959353, MIL-STD-777 Modified for DDG-51 Class, Schedule of Piping, Valves, Fittings, and Associated Piping Components

3. REQUIREMENTS:

3.1 Accomplish a preliminary air test of spaces in accordance with the following:

3.1.1 Install expandable plugs or blanks in associated tank piping at the first valve, flange, mechanical joint, or piping terminating in the tank. Associated piping is defined as "an assembly of pipe, tubing, valves, fittings and related components forming a whole or a part of a system which starts or terminates in subject area, thus being common to and associated with same."

3.1.1.1 Submit four legible copies of a report listing the location of each expandable plug and blank to NAVSHIPREPFAC.

3.1.2 Install two independent pressure gages.

3.1.2.1 Gage range shall be such that the test pressure is in the middle third of the scale.

3.1.3 Install two relief valves set at 15 percent above test pressure.

3.1.4 Install one vent valve.

3.1.5 The air source shall not exceed 25 PSIG and shall have a supply capability less than the exhaust capability of either relief valve.

3.1.6 Apply a soap solution to the opposite side of the structure and inspect for leakage.

3.1.7 Submit the original and two legible copies of Air Test Record (NAVSHIPREPFAC FORM 4355/2), listing the results of the preliminary air test, to NAVSHIPREPFAC.

3.1.8 Remove each expandable plug or blank upon completion of repairs and testing, and install new gaskets and fasteners in accordance with applicable Categories and Group of 2.a or 2.b.

3.1.8.1 Submit four legible copies of a report listing the location of each expandable plug and blank removed to NAVSHIPREPFAC.

(I)(G) or (V)(G) "AIR TEST" (See 4.1 for criteria.)

3.2 Accomplish an air test of spaces in accordance with the following:

3.2.1 Install expandable plugs or blanks in associated tank piping at the first valve, flange, mechanical joint, or piping terminating in the tank. Associated piping is defined as "an assembly of pipe, tubing, valves, fittings and related components forming a whole or a part of a system which starts or terminates in subject area, thus being common to and associated with same."

3.2.1.1 Submit four legible copies of a report listing the location of each expandable plug and blank to NAVSHIPREPFAC.

3.2.2 Install two independent pressure gages.

3.2.2.1 Gage range shall be such that the test pressure is in the middle third of the scale.

3.2.3 Install two relief valves set at 15 percent above test pressure.

3.2.4 Install one vent valve.

3.2.5 The air source shall not exceed 25 PSIG and shall have a supply capability less than the exhaust capability of either relief valve.

3.2.6 Remove each expandable plug or blank upon completion of repairs and testing, and install new gaskets and fasteners in accordance with applicable Categories and Group of 2.a or 2.b.

3.2.6.1 Submit four legible copies of a report listing the location of each expandable plug and blank removed to NAVSHIPREPFAC.

3.2.7 Submit the original and two legible copies of Air Test Record (NAVSHIPREPFAC FORM 4355/2) to NAVSHIPREPFAC within a week after successful completion of final tightness test.

(I)(G) or (V)(G) "AIR HOSE TEST" (See 4.1 for criteria.)

3.3 Accomplish a local air hose test in accordance with the following:

3.3.1 Air hose nozzle shall be as close as possible and pressure directed at the structure under test in a manner most likely to disclose leaks.

3.3.1.1 The minimum nozzle diameter shall be 3/8 inch and the pressure shall be 90 PSIG.

3.3.2 Apply a soap solution to the opposite side of the structure and inspect for leakage.

(I)(G) or (V)(G) "WATER HOSE TEST" (See 4.1 for criteria.)

3.4 Accomplish a water hose test in accordance with the following:

3.4.1 Use a one and one-half inch hose with a minimum nozzle diameter of one-half inch at 50 PSIG nozzle pressure at a maximum distance of 10 feet from the surface being tested.

3.4.2 The stream of water shall be directed against the structure in a manner most likely to disclose leaks. The opposite side of the structure shall be inspected to detect and locate leaks.

(I)(G) or (V)(G) "VACUUM BOX TEST" (See 4.1 for criteria.)

3.5 Accomplish a local vacuum box test in accordance with the following:

3.5.1 Install a vacuum box with a clear cover over the entire joint or fitting being tested.

3.5.1.1 Install the vacuum box so that the pressure differential is in the direction of an air test.

3.5.2 Apply a soap solution to the structure being tested.

3.5.3 Draw a vacuum of at least 10.2 inches of mercury and inspect for leaks.

4. NOTES:

4.1 The paragraph referencing this note is considered (I)(G) if the test is for work that requires record retention by the fabrication document. If the test is for work that does not require record retention, then the paragraph is considered to be (V)(G).